

20-8627



Dart Aerospace Ltd.
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D3295-041
Job Sheet 213618



Part No: D3295-041

Job Qty: 8 pcs

DAS
21
9-00

Part Name: Replacement Interior Window For -111



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/16/20

Description:

Type: SOLD

Note: DWG REV E IPP C 05.06.20 D3295-1 no longer made in-house KJ/JLM IPP Rev:D Added DT8822 07-03-20
JLM IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		10/15/20	0.04	1.24	Waterjet - Flow		020/10/13
110	QC 2	8 pcs		10/15/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		020/10/13
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	8 pcs	10/15/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
130 Small Fab - 2 - B4B	8 pcs	10/16/20	0.00 1.74	QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 QC 5	8 pcs	10/16/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

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OCT 20 2020

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
150	Packaging 3-1 - Stock - B4B	8 7 pcs	10/16/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
160	QC 21 - SA	8 pcs	10/16/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab)
 140 - QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MLEXS.125-9034-01	1/8" 9034 Lexan Sheet (Clear)	9.9200 sf (1.24 ea)	100-Waterjet - Flow - 1	5236576 8274216
D2728-1	Dart Logo Label Small	8 pcs (1 ea)	130-Small Fab - 2 - B4B	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MLEXS.125-9034-01	10	174	0
130-Small Fab - 2 - B4B	D2728-1	8	8,872	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 213618
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.166	+0.005/-0.001	0.155	1		Vide-04	
17.13	+/-0.030	17.13	1		Tap	
10.43	+/-0.030	10.43	1		"	
14.35	+/-0.030	14.35	1		"	
8.98	+/-0.030	8.98	1		"	
0.625	+/-0.010	0.627	1		Vide-04	
7.109	+/-0.010	7.109	1		" "	
15.845	+/-0.010	15.845	1		Tap	
2.308	+/-0.010	2.310	1		Vide-04	
5.420	+/-0.010	5.424	1		" "	
9.402	+/-0.010	9.405	1		Vide-01	
1.312	+/-0.010	1.311	1		Vide-04	
6.260	+/-0.010	6.262	1		" "	
12.520	+/-0.010	12.520	1		Tap	
0.313	+/-0.010	0.317	1		Vide-04	
3.750	+/-0.010	3.749	1		" "	
8.150	+/-0.010	8.153	1		Vide-01	
9.006	+/-0.010	9.005	1		" "	
0.125	+/-0.010	0.119	1		Vide-04	

Measured by: <i>de</i>	Audited by: JAS 10	Preliminary Approval:
Date: 20/10/13	Date: OCT 13 2020	Date:

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	



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Container No: S306171



Part: D3295-041

Job No: 213618

Serial No/Batch: S306171

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/14/20

Entered: UE Date: OCT 30 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>213618</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D3295-041</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: <u>20/10/2020</u>	Sequence #: <u>130</u>	QTY Affected: <u>1</u>			MRB (QSI042) DAS 9 9-89 <u>10-10-21</u>		
Description Work Order Deviation		Disposition			Completed By <u>[Signature]</u> OCT 20 2020 Lead hand / Supervisor DAS 58 9-89 OCT 20 2020 QC / QA Coordinator DAS 9 9-89 <u>20-10-21</u>		
There was a scratch on the window		swap & destroy					
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ ☒ Broken/Damage/Defect Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					